

Date: Thursday, 17/04/2008 10:59:09 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 38653
 Estimate Number : 10530
 P.O. Number :
 This Issue : 17/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2571
 Drawing Number : D2571 REV E
 Project Number : N/A
 Drawing Revision : E
 First Issue : 17/04/2008 Type : MACHINED PARTS
 Material :
 Previous Run : 37921 Due Date : 01/05/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : JLD 08.4.17
 Comment : Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 Saddle Billet



Comment: Qty: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: _____

5x 31389
 3x34875

28 08/05/05

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 28 Double check by: JLD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

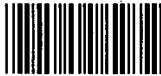
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

DIP / 28 08/05/05

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

DIP 08/05/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:10 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 38653

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/05/14

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

RD/m-f

08/05

(8X)

30min

15/05/2008

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107925

m-f

08/05

S.249 1.59

#1 318.8 F

#2 338653 F

#3 02571 F

#4

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

BL

08-05-15

(8)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS

08/05/15

(8)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/16

Job Completion



MF 08-05-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38053
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.008	7.998	7.999	7.999		
F	0.490	0.510		0.506	.490	.501	0.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.502	.503	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	.578	.579	.579		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.131	.131	.131	.132		
Q	0.115	0.135		0.135	.135	.135	.132		
R	0.240	0.260		.258	.258	.258	.258		
S	0.115	0.135		0.134	.132	.135	.131		
T	0.178	0.198		.180	.184	.184	.184		
U	2.940	2.980		2.964	2.962	2.962	2.962		
V	0.230	0.250		0.240	.245	.247	.246		
W	0.115	0.135		0.124	.123	.125	.135		
X	0.308	0.313		.312	.312	.312	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.365	.365	.368	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.625	.635	.628	0.630		
AC	0.053	0.073		0.062	.062	.062	0.062		
AD	0.240	0.260		0.250	.250	.250	.250		
AE	1.375	1.395		1.392	1.385	1.384	1.384		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		.260	.265	.265	.265		
AH	0.240	0.260		0.251	.258	.259	.257		
AI	2.000	2.020		2.007	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: JTP
Date: 08/05/06 / 08/05/08

Audited by: SA
Date: 08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38653
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	62	73	84		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.748	1.749		
C	3.495	3.505		3.500	3.498	3.499	3.499		
D	1.745	1.755		1.750	1.748	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.510	0.506	0.5045	0.504		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.508	0.506	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.575	.578	0.574	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.132	.130	.124	.120		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.260	.248	.249	.248		
S	0.115	0.135		.132	.131	0.132	0.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.245	.247	0.246	0.234		
W	0.115	0.135		.133	.133	0.135	0.122		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	0.363	0.364	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.630	0.627	0.630	0.632		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		.250	.250	.250	0.243		
AE	1.375	1.395		1.383	1.384	1.384	1.3845		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.246	0.243		
AI	2.000	2.020		2.003	2.003	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>SS</i>
Date: <i>08/05/14</i>

Audited by: <i>SA</i>
Date: <i>08/05/14</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SS</i>

RELEASED

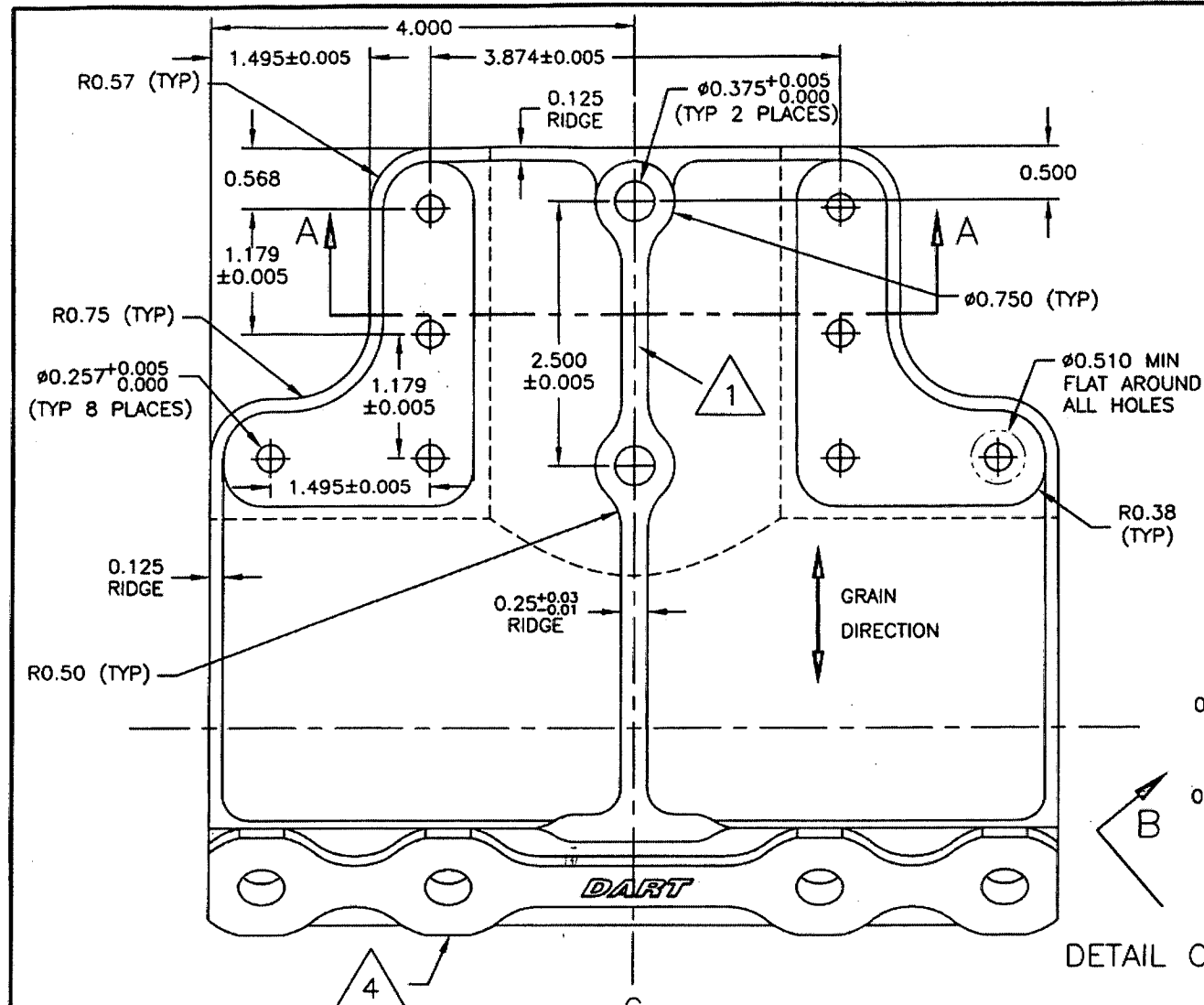
05.12.06

NOTES

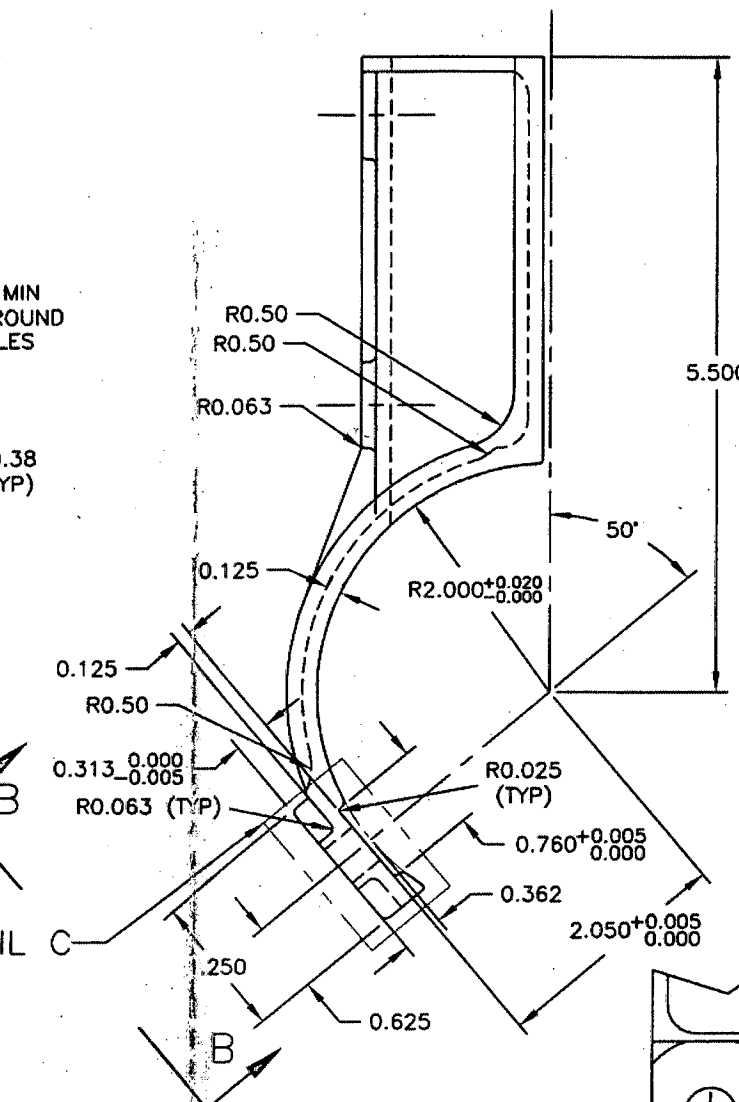
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

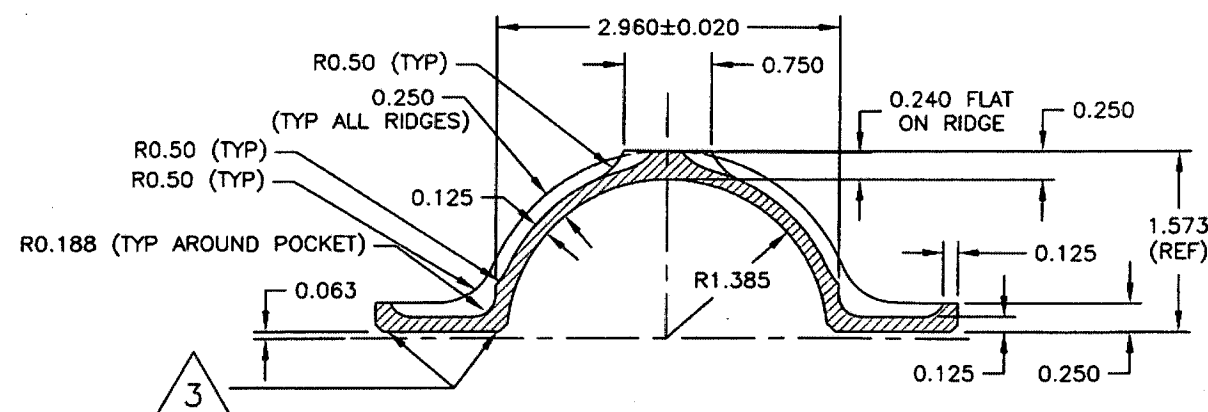
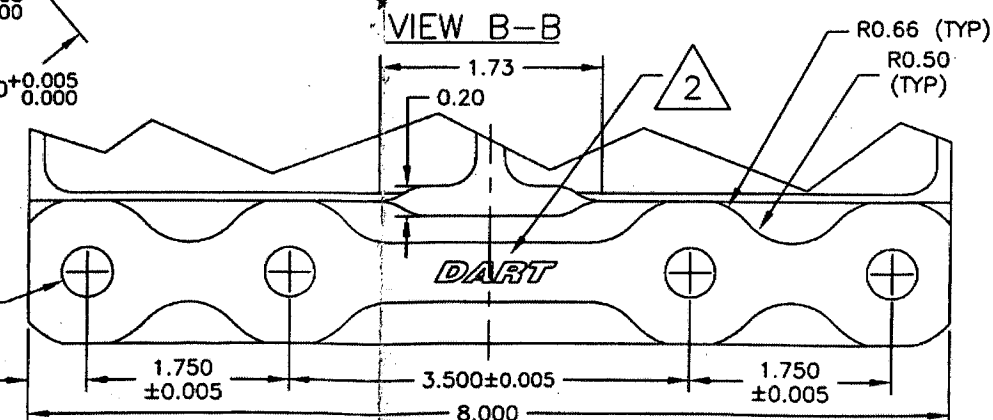
SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 38653



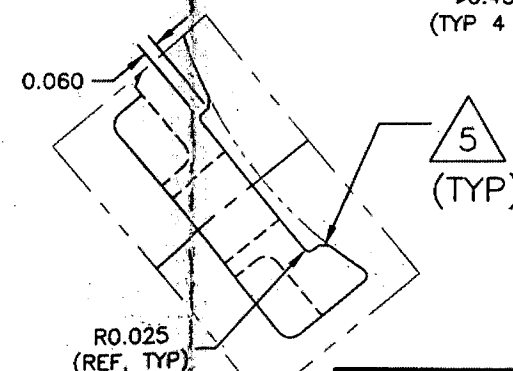
DETAIL C



VIEW B-B



SECTION A-A



DETAIL A
 SCALE 4:3

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E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE

DART DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2571
 SHEET 1 OF 1

2:3

